

Date: Thursday, 10/08/2006 10:04:21 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BASKET BASE ASSEMBLY (350)	
Job Number	28140C	Part Number	D2221	
Estimate Number	10189	Drawing Number	D2221/D2235	
P.O. Number	N/A	Project Number	N/A	
This Issue	10/08/2006	S.O. No.	N/A	
Prsht Rev.	NC	Type	LARGE FAB ASSY	
First Issue	N/A	Material	N/A	
Previous Run	28039A	Due Date	31/08/2006	Qty: 1 Um: Each
Written By				
Checked & Approved By				
Comment	Est Rev:J 05.09.02 Added D3442-1KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	D31661	Basket Hoop		
 Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Pick: Qty Part Number Description Batch 4 D3166-1 RIB B28094				
 <i>10/08/10</i>				
2.0	D22323	Basket Hinge		
 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)				
Pick: Qty Part Number Description Batch 2 D2232-3 Hinge bracket B24527				
 <i>10/08/10</i>				
3.0	D2325	Support Gusset (350 Bask)		
 Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Pick: Qty Part Number Description Batch 4 D2325 Support Gusset B27582				
 <i>10/08/10</i>				
4.0	D23273	Spacer Bushing		
 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)				
Pick: Qty Part Number Description Batch 2 D2327-3 Bushing B27051				
 <i>10/08/10</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:04:22 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28140C

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B27524

10/08/10 ①

6.0	D34421	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3442-1	Shim	B26739

10/08/10 ①

7.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty	Part Number	Description	Batch
36 sf	M304EX0.75-16F	Expanded Metal	M101341

10/08/10 ②

8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M101561

10/08/10 ②

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

10/08/10 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-08-22 ①

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-08-24

①

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 06-08-28

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M101855

Expiry date: 02/2007

mf. 06-08-28

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06-08-30

Job Completion



Lacelle/29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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